

## CLAIMS

1. A turn-table type roll stock apparatus, wherein the same is constituted such that many process rolls can be stood obliquely in a circumferential arrangement in one stage or two stages at a roll pallet in such a way that a longitudinal direction of the process rolls may coincide with a generatrix at a conical surface and an optional roll pallet can be stopped at a predetermined position so as to store or take out the process rolls against the roll pallet.

2. The turn-table type roll stock apparatus according to claim 1, wherein the same is constructed such that the roll pallet is comprised of a lower supporting member having two flat surfaces for supporting the two right and left points at a slant side of a lower end of said process roll at the same positions when one process roll of optional length and optional outer diameter is stood obliquely, and an upper supporting member having two flat surfaces for supporting the two right and left points at a slant side of an upper end of said process roll at the same positions the lower end of the lower supporting member is provided with a projected roll lower end surface supporting plate for supporting the lower end surface of the process roll in such a way that the lower end of the process roll is not slipped away from the roll supporting surfaces of the lower supporting member, the upper side supporting member is of longitudinal two-

surfaces having an obtuse angle at its horizontal sectional view, as the length of the process roll is made short, its inclination is increased to cause a distance in a horizontal direction between the center of gravity and the lower end of the roll to be widely changed and even if a centrifugal force is applied to the process roll at the time of rotation of the turn-table, it rises in an upright direction and it is not fallen more outwardly.

3. A plating factory for process roll for a gravure printing, wherein there is provided a plating line facility having a copper sulphate plating device or a chromium plating device or a nickel plating device or a zinc plating device for use in plating a process roll, further there is provided an industrial robot having a robot hand adjacent to one end of a line of the plating line facility so as to chuck the process roll at its both ends to enable a handling of the roll to be carried out; there is provided, in a handling area of said industrial robot, one or a plurality of turn-table type roll stock devices capable of standing obliquely many process rolls in a circumferential arrangement in one stage or two stages at the roll pallet in such a way that a longitudinal direction of the process roll may be coincided with the generatrix of a conical surface and capable of stopping an optional roll pallet at a predetermined position so as to store or take out the process roll against the roll pallet; the industrial robot takes out the process roll stored at the roll stock device,

delivers it to the roll handling means in the plating line facility, and additionally receives the process roll from the roll handling means in the plating line facility and stores it at the roll stock device.

4. The plating factory for process roll for a gravure printing according to claim 3, wherein a grinder stone grinding device is installed at a location near the industrial robot in said plating line facility or outside said plating line facility.